

Work Order ID 150827

Thursday, September 08, 2016 8:33:40 AM

150827

AMOD

DG

Page 1

Item ID: D412-630-033DG

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Stop

NS2

Start Date: 9/30/2016 Start Qty: 3.00

3

Cust Item ID:

Required Date: 10/31/2016 Req'd Qty: 3.00

3

Customer:

Reference:

DAS
21

Approvals: Process Plan: DAS 21 9-89 Date: SEP 08 2016

Tooling:

Date:

Run Start

NR1

QC: Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

Rev O

DAS
6
9-89

OCT 20 2016

DAS
21
9-89

16-10-21

100

Document Control

0.00

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & create labels per PPP D412-630-033 CHG005

3x

DAS
28
9-89

NOV 15 2016

3

110

Small Fab

0.00

110

Small Fab

Memo

0.16

Small Fab

Assemble as per dwg D412-630 p.14

Coat all hardware with LPS3 rust inhibitor

A/R LPS3 batch: 123777

COAT exposed HARDWARE WITH LPS PROCYON.

A/R LPS PROCYON BATCH: 133690

3x

16/11/15 DAS 36 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval 	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	

Root Cause	FAULT CATEGORY		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
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Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.01

Quality Control

DAS
38
9-89
NOV 15 2016

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

3 DAS
6
9-89
OCT 26 2016 DAS
27
9-89

140

QC4- 100% Inspect kits for completeness

0.00

140

QC

Memo

0.02

Quality Control

3x DAS
28
9-89
NOV 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Page 3

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016 Start Qty: 3.00

3

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Required Date: 10/31/2016 Req'd Qty: 3.00

3

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Packaging	0.00							
150									
Packaging	Memo	0.00				3X	DAS 28 9-89	DAS 27 9-89	NOV 15 2016
Packaging	Identify and pack for shipping as per PPP D412-630-033 Location: _____ PPP Rev: _____								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.05					DAS 21 9-89		NOV 15 2016
Quality Control									

DAS
21
9-89 NOV 15 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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OTHER : ☐					

Picklist Print

Thursday, September 08, 2016 8:33:43 AM

Page 1

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A New Issue 06-11-08 JLM
IPP rev B ecn 1019, added d2807-041 EC verified by:DD
IPP rev :C 11.01.06 added route seq ID DD vef:EC IPP REV:D
13.06.07 PER CHG004 DD vef:JLM IPP REV:E 16.06.23
AS PER IIN REV.O DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310C8 *AN310C8* Nut		Purchased	No			110	Each	24.0000	2	6		OCT 26 2016	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST331		24							
				m132677		4							
				m135297		20							
AN3C21A *AN3C21A* Bolt		Purchased	No			110	Each	21.0000	1	3		OCT 26 2016	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		21							
				M133686		21							
AN8C16 *AN8C16* Bolt		Purchased	No			110	Each	39.0000	2	6		OCT 26 2016	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				over005		21							
				M133920		7							
				M133921		7							
				M134131		7							
				ST332		18							
				M132674		4							
				M133091		7							
				M133336		7							

DQA: _____ Date: _____



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QA Closed: _____ Date: _____

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Page 2

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D2012-107

Manufactured No

110

Each

59.0000

1

3

D2012-107

Clevis

**

OCT 26 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

WA004

59

145274

8

149315

51

3

D2803-041

Manufactured No

110

Each

8.0000

1

3

D2803-041

Bracket Assembly

**

DAS
36
9-89
16/11/15

Location

Loc Qty

Loc Code

ST472

8

148426

8

B149454 (3x)

D2804-041

Manufactured No

110

Each

1.0000

1

3

D2804-041

Bracket Assembly

**

DAS
36
9-89
16/11/15

Location

Loc Qty

Loc Code

ST474

1

148422

1

B149403 (3x)

D2807-041

Manufactured No

110

Each

37.0000

2

6

D2807-041

Prop Assembly

**

149200 OCT 26 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

FG

2

89606

2

ST011

35

142559

1

148998

4

149206

30

Thursday, September 08, 2016 8:33:43 AM

Shop Packet Print

Page 2

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150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D2813 Manufactured No 110 Each 122.0000 2 6

D2813

Washer

**

OCT 26 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST011

122

146527

18

149366

104

D3395-1

Manufactured No

110 Each 264.0000 4 12

D3395-1

Bushing

**

OCT 26 2016

DAS
6
9-89

Location

Loc Qty

Loc Code

ST034

264

142347

62

149467

202

D3562-041

Manufactured No

110 Each 0.0000 1 3

D3562-041

Step Weldment

**

16/11/15

DAS
36
9-89

149390 (3x)

Thursday, September 08, 2016 8:33:43 AM

Shop Packet Print

Page 3

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				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Thursday, September 08, 2016 8:33:43 AM

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-3 Purchased No 110 Each 1,202.000 4 12

MS21043-3

Nut

**

DAS

OCT 26 2016

6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	80	
103691	80	
FP001	11	
m130673	11	
GA	235	
m133990	235	
ST302	807	
m135058	7	
m135442	400	
m135544	400	
ST304	69	
m131340	69	

12

MS24665-302 Purchased No 110 Each 29.0000 2 6

MS24665-302

Cotter Pin

**

DAS

135672

OCT 26 2016

6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	15	
120521	15	
ST288	14	
m134738	14	

MS24693-C280 Purchased No 110 Each 11.0000 2 6

MS24693-C280

SCREW

**

DAS

135672

OCT 26 2016

6
9-89

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST287	11	
m131624	11	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐			FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

Thursday, September 08, 2016 8:33:43 AM

Page 5

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS24693-C285

Purchased

No

110

Each

28.0000

1

3

MS24693-C285

Screw

**

135704

DAS
6
9-89

OCT 26 2016

Location

Loc Qty

Loc Code

ST287

28

m134558

28

AN44C7A

Purchased

No

130

Each

11.0000

1

3

AN44C7A

Eyebolt

**

135704

DAS
6
9-89

NOV 02 2016

Location

Loc Qty

Loc Code

ST339

11

m134502

2

m135127

9

AN4C10A

Purchased

No

130

Each

17.0000

1

3

AN4C10A

BOLT

**

135671

DAS
6
9-89

DAS
27
9-89

NOV 02 2016

Location

Loc Qty

Loc Code

ST345

17

M134497

7

M135390

10

DAS
28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER : _____						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Thursday, September 08, 2016 8:33:43 AM

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

AN4C15A

Purchased

No

130

Each

96.0000

2

6

AN4C15A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

10

120360

10

OVER002

50

M132763

20

M133485

30

ST343

36

M130716

22

M132189

8

M132823

6

**

135672X5

NOV 02 2016

DAS
6
9-89

DAS
27
9-89

AN4C6A

Purchased

No

130

Each

590.0000

1

3

AN4C6A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

FG

14

103344

4

121657

10

OVER002

450

m135297

50

m135470

400

over003

126

m135442

126

**

NOV 02 2016

DAS
6
9-89

DAS
27
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

Picklist Print

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Page 7

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

AN5C15A Purchased No 130 Each 121.0000 2 6

AN5C15A

Bolt

**

NOV 02 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

over003 110
M135442 110
ST337 11
M135058 11

D2806-1 Manufactured No 130 Each 119.0000 2 6

D2806-1

Bushing

**

NOV 02 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST011 18
142466 2
148274 16
ST012a 101
149371 101

D2806-3 Manufactured No 130 Each 117.0000 2 6

D2806-3

Bushing

**

NOV 02 2016

DAS
6
9-89

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST011 16
148330 16
ST012a 101
149456 101

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Shop Packet Print

Page 7

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____					

Picklist Print

Thursday, September 08, 2016 8:33:43 AM

Page 8

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D2810-5 Manufactured No 130 Each 6.0000

D2810-5

Strut

1 3

** 149359

NOV 02 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST377

6

134899

1

142838

5

D3396-1 Manufactured No 130 Each 108.0000

D3396-1

Spacer

2 6

**

NOV 02 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST034

6

142351

6

ST038A

102

149446

102

D3672-17 Manufactured No 130 Each 354.0000

D3672-17

Phenolic Washer

7 21

**

NOV 02 2016

DAS 6 27
9-89 9-89

Location

Loc Qty

Loc Code

ST050

354

148074

354

D3672-19 Manufactured No 130 Each 416.0000

D3672-19

Phenolic Washer

4 12

**

OCT 26 2016

DAS 6 9-89

Location

Loc Qty

Loc Code

ST050

416

148075

416

Thursday, September 08, 2016 8:33:43 AM

Shop Packet Print

Page 8

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition																					
								Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : _____																			

Picklist Print

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Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3672-5

Manufactured No

130 Each

622.0000

7

21

D3672-5

Washer, Phenolic

**

NOV 02 2016

DAS
28
9-89

pkg

Location

Loc Qty

Loc Code

FG	8	
44679	8	
ST049	234	
35521	234	
ST051A	380	
50354	380	

68-6
9
DAS
27
9-89

D3672-7

Manufactured No

130 Each

883.0000

4

12

D3672-7

Washer, Phenolic

**

OCT 26 2016

small fab

Location

Loc Qty

Loc Code

FG	40	
129987	25	
133986	15	
ST049	343	
147220	343	
ST057A	500	
149431	500	

DAS
6
9-89

12

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Shop Packet Print

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																																																																	
Large Fab ☐	Composite ☐	Supplier ☐																																																																		
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Picklist Print

Page 10

Thursday, September 08, 2016 8:33:43 AM

Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

MS21043-4

Purchased

No

130

Each

735.0000

4

12

MS21043-4

Nut

**

135200

DAS
6
9-89

NOV 02 2016

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	40	
104603	40	
GA	17	
m132803	17	
OVER007	300	
m135530	300	
ST302	378	
m135390	78	
m135407	300	

MS21043-5

Purchased

No

130

Each

136.0000

3

9

MS21043-5

Nut

**

135701

DAS
6
9-89

NOV 02 2016

DAS
27
9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

FG	20	
101418	20	
GA	72	
116548	72	
ST302	44	
m135157	2	
m135470	42	

Thursday, September 08, 2016 8:33:43 AM

Shop Packet Print

Page 10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																																																

Picklist Print

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Work Order ID: 150827

150827

Parent Item: D412-630-033DG

D412-630-033DG

Parent Item Name: Folding Heli-Access-Step™ LH - Low, High & Float Gear, Drab Green

Start Date: 9/30/2016

Required Date: 10/31/2016

Start Qty: 3.00

Required Qty: 3.00

D3672-15

Manufactured No

160

Each

731.0000

5

D3672-15

Phenolic Washer

15
DAS
6
9-89

OCT 26 2016

small fab

Location

Loc Qty

Loc Code

ST050

231

148073

231

ST051A

500

149430

500

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Qty -033	Qty -034	Qty -243	Qty -244	Part Number	Description
X				D412-630-033	HELI-ACCESS-STEP™ LH (FOLDING)
	X			D412-630-034	HELI-ACCESS-STEP™ RH (FOLDING)
1		X		D412-630-243	STEP ASSEMBLY LH
	1		X	D412-630-244	STEP ASSEMBLY RH
		1	1	D2012-107	CLEVIS
		1		D2803-041	STA 84 BRACKET ASSEMBLY LH
			1	D2803-042	STA 84 BRACKET ASSEMBLY RH
		1		D2804-041	STA 155 BRACKET ASSEMBLY LH
			1	D2804-042	STA 155 BRACKET ASSEMBLY RH
2	2			D2806-1	BUSHING
2	2			D2806-3	BUSHING
		2	2	D2807-041	GAS SPRING ASSEMBLY (WAS D2807)
1	1			D2810-5	STRUT
		2	2	D2813	WASHER
		1		D3562-041	STEP WELDMENT LH
			1	D3562-042	STEP WELDMENT RH
		4	4	D3395-1	BUSHING
2	2			D3396-1	SPACER
7	7			D3672-5	WASHER (OR NAS1515H5)
		4	4	D3672-7	WASHER (OR NAS1515H5L)
		5	5	D3672-15	WASHER (OR NAS1515H3)
7	7			D3672-17	WASHER (OR NAS1515H4)
		4	4	D3672-19	WASHER (OR NAS1515H8)
		1	1	AN3C21A	BOLT
1	1			AN4C6A	BOLT
1	1			AN4C10A	BOLT
2	2			AN4C15A	BOLT
1	1			AN44-C7A	EYEBOLT
2	2			AN5C15A	BOLT
		2	2	AN8C16	BOLT
		2	2	AN310C8	NUT
		2	2	MS24665-302	COTTER PIN (OR AN380C3-4)
		4	4	MS21043-3	NUT
4	4			MS21043-4	NUT
3	3			MS21043-5	NUT
		2	2	MS24693-C280	SCREW (OR MS24694-C65)
		1	1	MS24693-C285	SCREW (OR MS24694-C76)